

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022073**Date Inspected:** 25-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, OBG Segment 13CE, DP Transverse Seam

This QA Inspector performed verification Ultrasonic Testing (ABF UT Report No: UT-13E-008-R1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between two plates of deck panels of segment 13CE. The weld designations were as:

DP3106-001-175, 137

DP3105-001-175, 137

DP3104-001-010, 009

DP3103-001-302, 301

DP3102-001-010

DP3107-001-137

DP3106B-001-137

WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020X-012 [Bottom Plate (BP) 3090A to Longitudinal Diaphragm (LD) 3049B, CJP weld at panel point (PP) 125.5]. The welder is identified as 045276 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020X-008 [Floor Beam (FB) 3329A to Longitudinal Diaphragm (LD) 3051, CJP weld at panel point (PP) 127]. The welder is identified as 045227 and was observed welding in the 3G position. ZPMC QC was identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020X-014 [Bottom Plate (BP) 3090A to Longitudinal Diaphragm (LD) 3049A, CJP weld at panel point (PP) 126.5]. The welder is identified as 068994 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020Y-013 [Bottom Plate (BP) 3091A to Longitudinal Diaphragm (LD) 3051, CJP weld at panel point (PP) 128.3]. The welder is identified as 047864 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
